13

DART AEROSPACE LTD	Work Order:	20429
Description: Run-on Landing Wearplate Kit	Part Number:	DSI 9247-011
Dwg: D3184 Rev. A1	Qty:	5 Kit
RF 04.02.24		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.02.24	5
2	DC	Photocopy bluefile and create labels per PPP DSI 9247-011 **CHG001** WK 11 KJ	DR	05/11/30	5
3	PG	Issue P/O: 1006142 **Email or Ship DXF file to vendor** ORDER **(4) D3184-11** AND **(2) D3184-1** TO MAKE (1) KIT Laser Cut D3184-1 & D3184-11 Flat pattern as per Dwg D3184 **Material release note required**	LL	04.02.25	5
4	RG	Receive and inspect for transit damage **Ensure the material release note is attached**	[illegible]	04.03.10	5kits
5	QC6	Inspect dimensions per templates D3184-1T1 & D3184-11T1	[illegible]	04/03/11	5 (PTO)
6	GA	Deburr if necessary	[illegible]	[illegible] 04.13	5
7	GA	Bend D3184-1 as per Dwg D3184	[illegible]	04.04.13	4½ Ptd
8	GA	Bend half of D3184-11 as D3184-3 & other half of D3184-11 as D3184-4 as per Dwg D3184 **Note: Orientation of the bend**	[illegible]	04.04.13	4½
9	QC5	Inspect work to Step 8	[illegible]	04/11/16	4 (PTO)
10	WS	Weld cup & D3184-3/-4 to D3184-1 as per Dwg D3184 & QSI 004 **Pick:** Qty / Part Number / Description / Batch 16 / D3009-1 / Cup / B 20432 Weld Rod / M 9326	CPL	05.11.28	4
11	WS	Weld hardcoat as per Dwg D3184 & QSI 004 **Pick:** Qty / Description / Batch A/R / 7560 Hardcoat Rod / M15341 **Identify weldment as D3184-041**	CPL	05.11.28	4
12	QC9 /5	Inspect work to Step 11	[illegible]	05.11.28	4
13	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) per QSI 005 4.3	JM	05 11 30	4
14	QC3	Inspect Powder Coat	CL	05/12/01	4
15	KP	**Pick: Packing Kit** Qty / Part Number / Description / Batch 2 / D3184-041 / Wearplate / B20428	[illegible]	05/12/01	4
16	QC4	Inspect Kit 100% for Completeness on the W/O	CL	05/12/02	4
17	ST	Identify and pack for shipping as per PPP DSI 9247-011 REV. DRAFT	[illegible]	05/12/02	4
18	AC	Cost / part	LL	05.12.07	4
19	DC	Close W/O Inspect Level 21	[illegible]	05/12/07	4

RF 03.11.11 KJ

Rev	Date	Change	Revised By	Approved
A	03.05.15	New issue	KJ/RF	[illegible]

H:\Forms\Quality Assurance\Approved QA\IPPSHORT revA

RELEASED 03.05.16 RF

Dart Aerospace Ltd

Work Order:	WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Manuf / Design Mgr	**Approval** QC Inspector
04/11/15	9	Send one For Welding Test D3184-1 Wearplate B20429	[signature]	04/11/15	1	[signature] 04/11/15	[signature] 04/11/15

NCR	WORK ORDER NON-CONFORMANCE							
DATE	**STEP**	**Description of NC** section A	**Corrective Action** Section B Intial		Sign & Date	**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
04.03.11	3	5.050 IS 4.780	[initial]	ACCEPTABLE DEVIATION ENSURE HOLES LINE UP WHEN WELDED TO D3184-1	[signature] 04.03.11	[signature] 06.12.03	[signature] 04.03.11	[signature] 06-12-03
04.04.13	7	one D3184-1 overbent wrong number entered into CNC Brake	[initial]	destroy piece	[signature] 04.04.13	[signature] 04.04.13	N/A	[signature] 04.04.13

PAR#: N/A Fault Category: N/A DQA: [signature] Date: 06/12/04

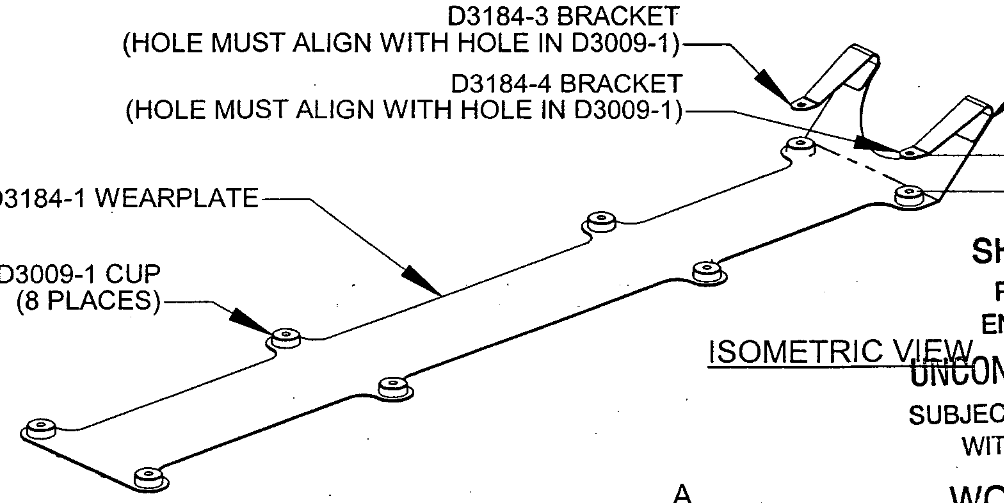
NOTE: Date & initial all entries
H:Admin-QA\ISO\forms\w/oncB.doc

QA: N/C Closed: ______ Date: ________

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3184	REV. A SHEET 1 OF 3
DATE 03.05.07		TITLE WEARPLATE	SCALE 1:6
A	03.05.07	NEW ISSUE	

QA COPY ISSUED

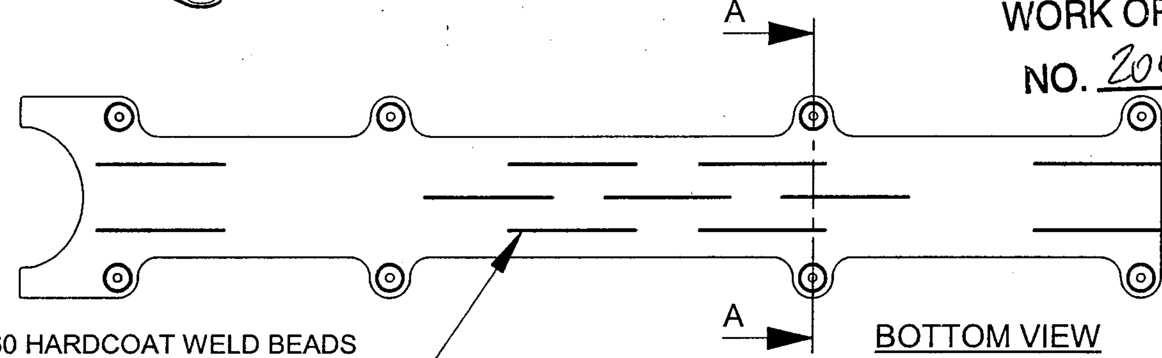
DART

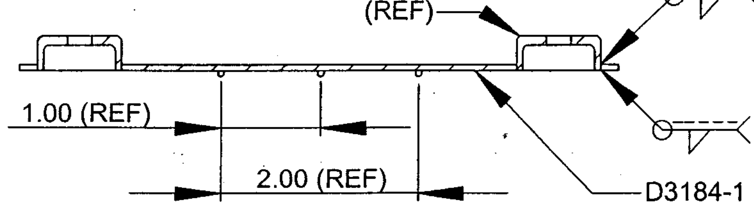


SHOP COPY
RETURN TO ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 20429





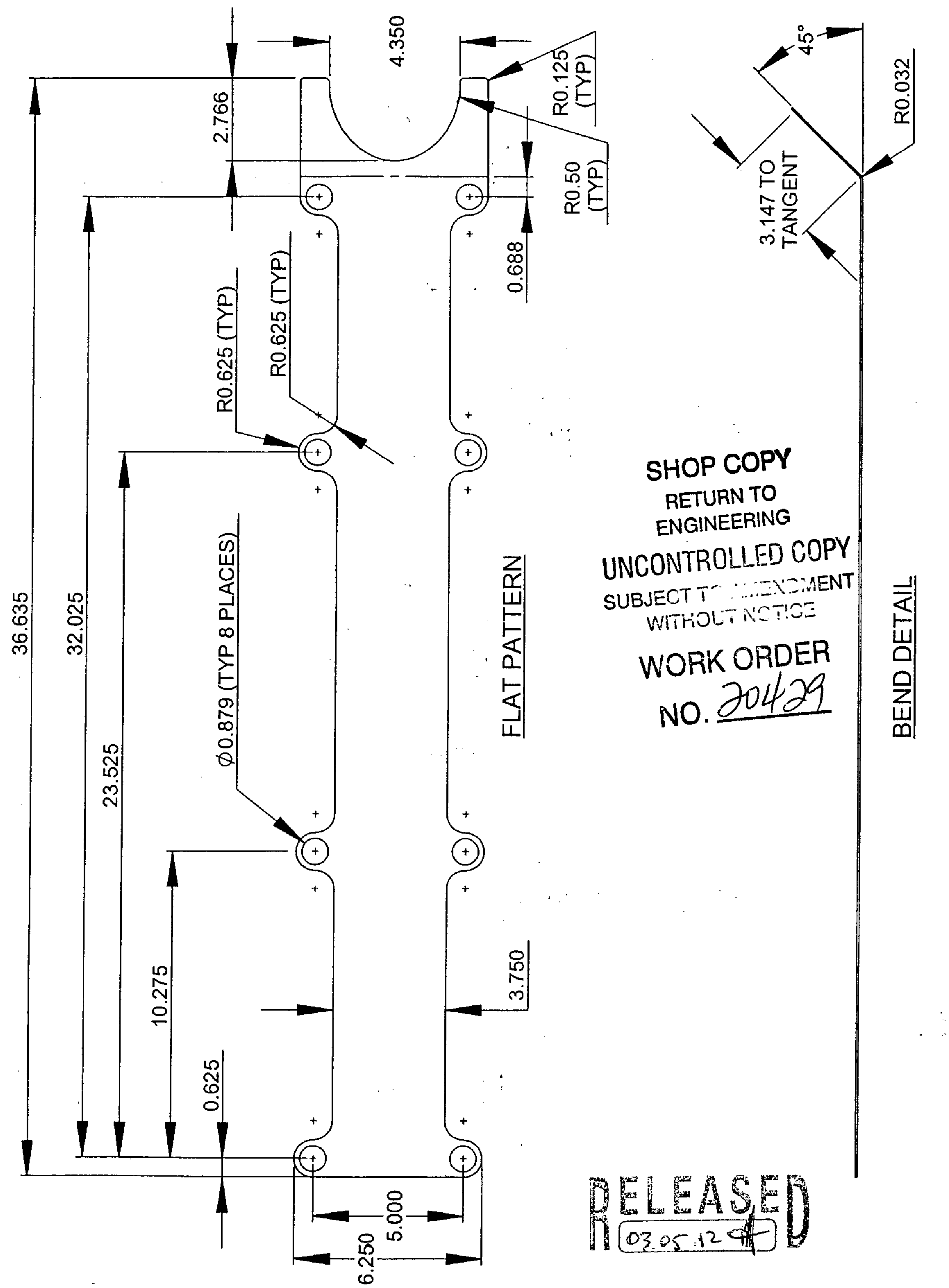
D3184-041 WEARPLATE

1) WELD PER QSI 004
2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

RELEASED 03.05.12

A1	03.11.24	UPDATE DWG TO MATCH PARTS

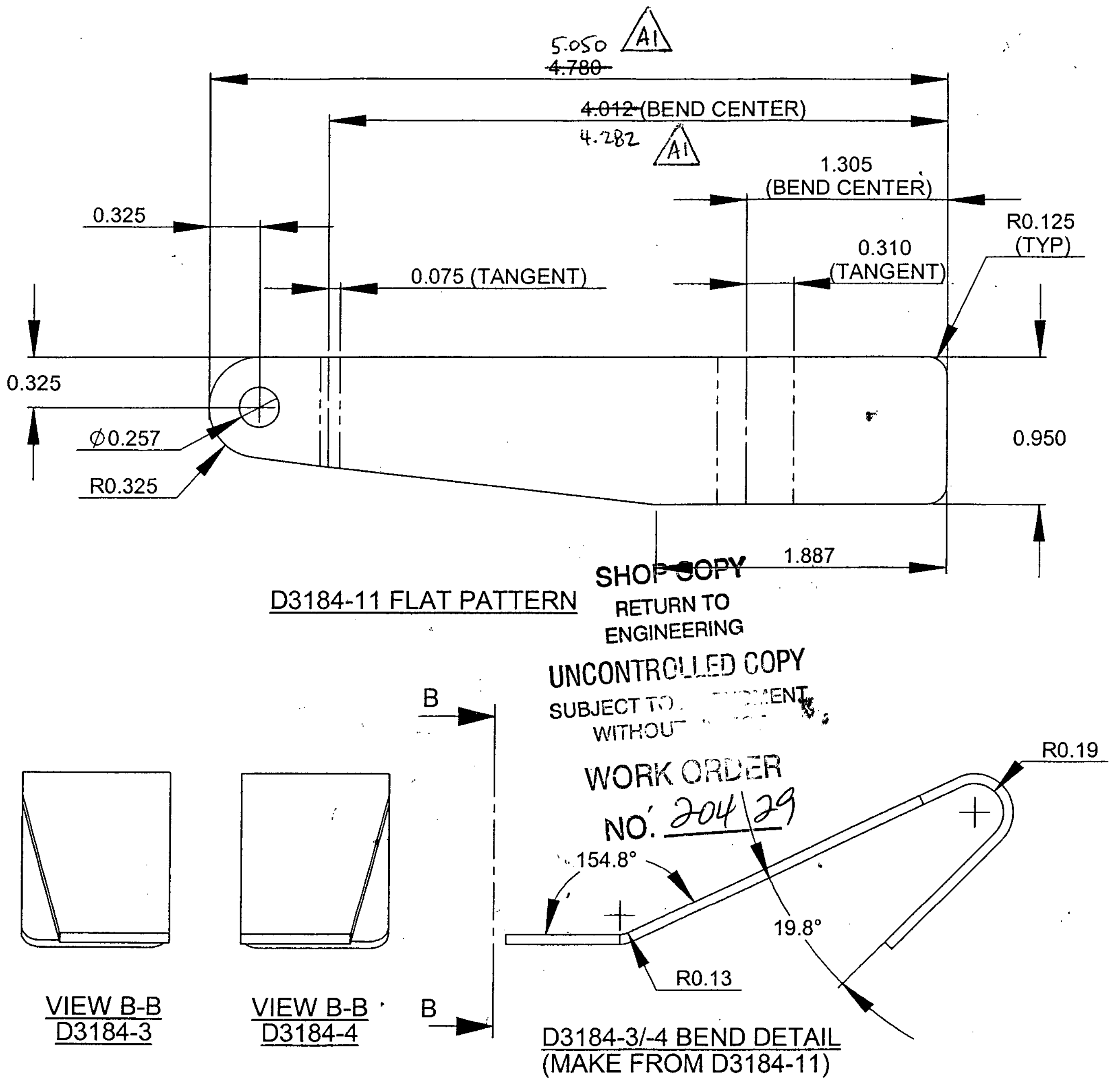
DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3184 — REV. A — SHEET 2 OF 3
DATE 03.05.07		TITLE WEARPLATE — SCALE 1:5



D3184-1 WEARPLATE

1) MACHINE PER DRAWING FILE "D3184-A.DRW"
2) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK) (REF DART SPEC. M1010-S16GA)
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3184 — REV. A — SHEET 3 OF 3
DATE 03.05.07		TITLE WEARPLATE — SCALE 1:1



D3184-3/-4 BRACKET NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK) (REF DART SPEC. M1010-S16GA)
2) BREAK ALL SHARP EDGES 0.005 TO 0.015
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

RELEASED 03.05.12

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 24, 2004
12:53 pm

Work Order No	: 0020429
Project Name	: *DSI 9247-011
Project For	: WK413
Work Order Type	: Main
Main WO Number	:
House Part Number	: *DSI 9247-011
Description	: Run-on Ldg Wearplate Kit
Manufactured	: Yes
Amount Req'd	: 5
Amount Done	: 0
Start Date	: 02-24-04
Est Finish Date	: 03-24-04
Act Finish Date	:
Drawings Reqd	: No
Ok for Approval	:
Approval Rec'd	:

Department Code	:
Burden Flags	: NNNNNNN
WO Status	: Open
Invoice State	: Not Invoiced
Invoice Date	:
Invoice Number	:
Invoice Amount	: 0.00
Order Entry No	:
OE Value	: 0.00
Est Margin	: 0.000%
Actual Margin	: 0.000%

$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

NAS NORTH AMERICAN STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 185045 02

Mail To:
ALASKAN COPPER & BRASS CANADA, INC.
P.O. BOX 3546
SEATTLE, WA 98124-3546

Ship To:
ALASKAN COPPER & BRASS CANADA, INC.
225 NORTH ROAD AVENUE
COQUITLAM, BC V3K3V7
CANADA

Date: 5/06/2003 Page: 1

Steel: 304

Finish: 2B

Your Order: V033868

NAS Order: AE 0249852 03

Corrosion: ASTM A262/01E;180 Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/01,A480/01,A666/00,ASMESA240/01,SA480/01,SA666/01
QQS766D-A X MG PRM,AMS5513G X MRK&FIN,MIL5059D,AMD3,X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	---------Length--------		Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET	8	42

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

MECHANICAL PROPERTIES

Product ID #	Coil #	loc	dir	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F	T	96.06	49.79	48.68	85.00	88.00

16 GA 304 2B.

QC ENGINEER [signature] 5 2003

Форма / Form Экспорт Export 0030054

Товаросопроводительный документ No / Shipping document No 0080312775

CERTIFICATE OF QUALITY

ISPAT KARMET

Продавец (экспортер) / Seller (exporter) 4379

Контракт No / Contract No KX0939

Ссылка / Ref. No CA017

ISPAT-KARMET
Karaganda obl., Temirtau
Republic of Kazakhstan

Приложение / Annex N 012

Вагон No / Wagon No 67501734

There is no radiation contamination of metal, natural background up to 0.2 mkR/hour. Control is done with SRP-1-88 dosimeter. Certificate about governmental verification dated 04.07.2003

Грузополучатель, страна / Consignee, country 124 Canada

P30618DI500

НТД / Standard ASTM 1003M-01 ASTM A1000M-02 ASTM A 568M-95

.0757 x 48

Показатели качества товара / Quality characteristics of goods

Химический состав (%) / Chemical composition (%)

Номера плавок / Heat No	Номера партий / Batch No	C x 100	Si x 100	Mn x 100	S x 1000	P x 1000	Cr x 100	Ni x 100	Cu x 100	As x 100	x 1000	Al x 100	Количество товара / Quantity	Группа поверхности / Surface grade	Сорт / Grade
[illegible]	9204	7.0	1.0	36.0	22.0	22.0	1.0	3.0	4.0		[illegible]		8		1

Механические свойства / Mechanical characteristics

Номера партий / Batch No	Предел прочности / UTS n/mm2	Предел текучести / Yield strength	Удлинение / Percent Elongation	Твердость / Hardness (HRB)	Холодный загиб / Cold bend test	Эриксен / Ericsen		Цементит / Cementite	Характер кромки / Edge classification	Плоскостность / Flatness	Класс вытяжки / Ocuracy	Категория / Category	Вытяжка / Drawing
9204	345.0 365.0	240.0 230.0	37.0 38.0		UD				CUT				

Ra=1.0/1.8

Указанный в настоящем документе товар соответствует ... It is hereby certified that the quality of goods mentioned in this document is in conformity with the Kazakhstan standards and the goods may be exported according to this document.

Маркировка / Marking

Mittal Steel Temirtau / Ispat Karmet Ltd. Temirtau Operations

Подпись / Signature, Date

BUSHKINA
27.08.2003
11008-2373
2136441

FROM : INDUSTRIAL LASER FAX NO. :604+946+4153 Mar. 10 2004 10:44AM P3

NO. 557 P.7/12

ALZ

Certificate of test – Certificat de Réception

Nr 2002.0037314

Your order n° : 0020(1072)37 SP788

Our order n°: 47912/329/03

STAINLESS STEEL COILS, COLD ROLLED, FINISH 2 B

Specifications	Type – Grade	Finish
ASTM A240/A 240M-01	TYPE 304 - S 30400	2B
ASME SA 240-01	TYPE 304 - S 30400	2B

K 138018   13801820

ASTM A262 E - 01 : OK

Dimensions: mm 3.04 1219.20 — inches 0.1200 48.000

UNS S 30400

ASTM A240 1050°C

AMS 5513-G98 — ASTM A276/00-A+A312/A312M-01(CHEM.COMP.)+A666/00 - MATERIAL MERCURY FREE - NO WELD REPAIRING

Chemical analysis

Elements	Ladle	Product
C	0.042	0.044
Mn	1.31	1.32
P	0.029	0.030
S	0.004	0.003
Si	0.48	0.48
Cr	18.20	18.22
Ni	8.14	8.13
N	0.057	0.055

Mechanical properties – ASTM A240 – 13801820

	min. KSI	(T)	(T)
		12.46X	7.96
Yield 0.2%	30	49.8	49.0
		54.1	52.8
Tensile	75	98.9	97.8
Elong. % A50	40	49	50
		50	50
Hardness HRB	92	89.0	91.0

THIS MATERIAL IS SATISFACTORY FOR ASME CODE SECTION VIII DIV 1 FABRICATION

Bend test 180° OK

OK

GOOD WORKMANSHIP, PERMISSIBLE VARIATIONS IN DIMENSIONS OK

Package Nr	Qty	Net weight (LBS)
11170017	1	20216

: CTL 3146

ALBERT METAL SALES LIMITED
389 DERRY ROAD EAST, SUITE 305
L5T2J8 MISSISSAUGA, ONTARIO
CANADA

ALZ — THE SURVEYOR – L'EXPERT – DER WERKSACHVERSTÄNDIGE

TOTAL: QTY 1 — NET WEIGHT (LBS) 20216

13.03.2002

11 GA 304 2B.